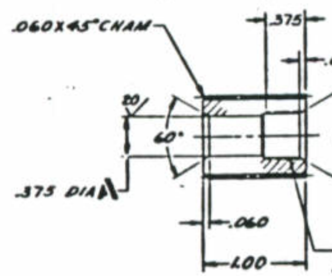
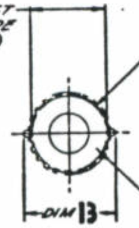
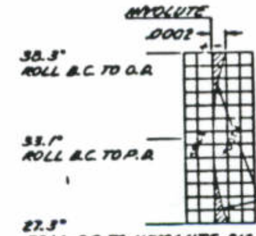






SHOP COPY

EXTERNAL SPLINE DATA
32/64 PITCH 24 TEETH
30° PRESSURE ANGLE
ARC TOOTH THICKNESS AT PD = DIM C
DIM OVER TWO .0540 DIA PINS = DIM B
RD = SEE NOTE
PD = .7500
OD = .781 +.003/-.000
ACTIVE PROFILE OUTSIDE .719 DIA
BREAK TIP .005 MAX
.306 R (MIN)

BASE CIRCLE DIA = .6495

MATL: SAE 01
HDN Rc 58-62

(1) DIM B = .8261 +.0003/-.0000, DIM C = .0491 +.0002/-.0000
(2) DIM B = .8271 +.0003/-.0000, DIM C = .0497 +.0002/-.0000
(3) DIM B = .8283 +.0003/-.0000, DIM C = .0505 +.0002/-.0000

NOTE:

RUNOUT BETWEEN O.D. AND PITCH LINE SHALL BE WITHIN .001 F.I.R.

RUNOUT BETWEEN DIA A AND PITCH LINE SHALL BE WITHIN .0002 F.I.R.

TOOTH SPACING MUST BE WITHIN .0002 ACCUMULATED ERROR. TAPER MUST BE WITHIN (2) PIN TOLERANCE. SPIRAL MUST NOT EXCEED .0002 IN SPLINE LENGTH. DIMENSION OVER (2) PINS TO BE WITHIN SPECIFIED TOLERANCE FOR 80% OF THE TEETH WHEN USING AN ANVIL PRESSURE OF (2) POUNDS. THE REMAINING TEETH MAY BE .0002 UNDERSIZE

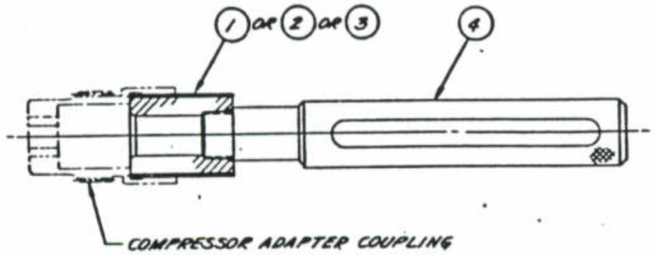
BREAK SHARP EDGES OF TEETH .005-.010

5	1	CASE			WOOD CONSTR	3
4	1	HANDLE			STL	2
3	1	SPLINE			STL	1
2	1	SPLINE			STL	1
1	1	SPLINE			STL	1
ITEM NO.	NO. REQD	NOMENCLATURE OR DESCRIPTION	CODE IDENT	PART OR IDENTIFYING NO.	MATERIAL OR NOTES	SH NO.

FOR PART IDENTIFICATION ITEM NUMBERS ARE EXPRESSED AS DASH NUMBERS OF THIS BASIC DRAWING, EXCEPT WHERE A NUMBER APPEARS IN THE PART OR IDENTIFYING NUMBER COLUMN

NOTE:
1. METAL STAMP OR ETCH AS SHOWN ON ITEMS 1 THRU 5
2. BLACK OXIDE ITEMS 1 THRU 4 PER AMS 2485. COAT WITH GREASE

REDUCED PRINT



EACH ITEM PURCHASED SEPARATELY MUST BE STAMPED OR ETCHED WITH TOOL NUMBER AND DETAIL NUMBER. IF SUITABLE OR SUFFICIENT AREA NOT AVAILABLE, ATTACH TAG.

USED ON ENGINE MODEL 250

BREAK SHARP EDGES .030 UOS

UNLESS OTHERWISE SPECIFIED
TOL ON ANGLES ±1°

MATL: SEE ITEM
HEAT TREAT AND HARDNESS: SEE ITEM
SURFACE TREAT: NOTED

AMS 2485 — LOCAL SPECS (REF)
DRAWING PRACTICE
SURFACE TEXTURE
SCREW THREADS

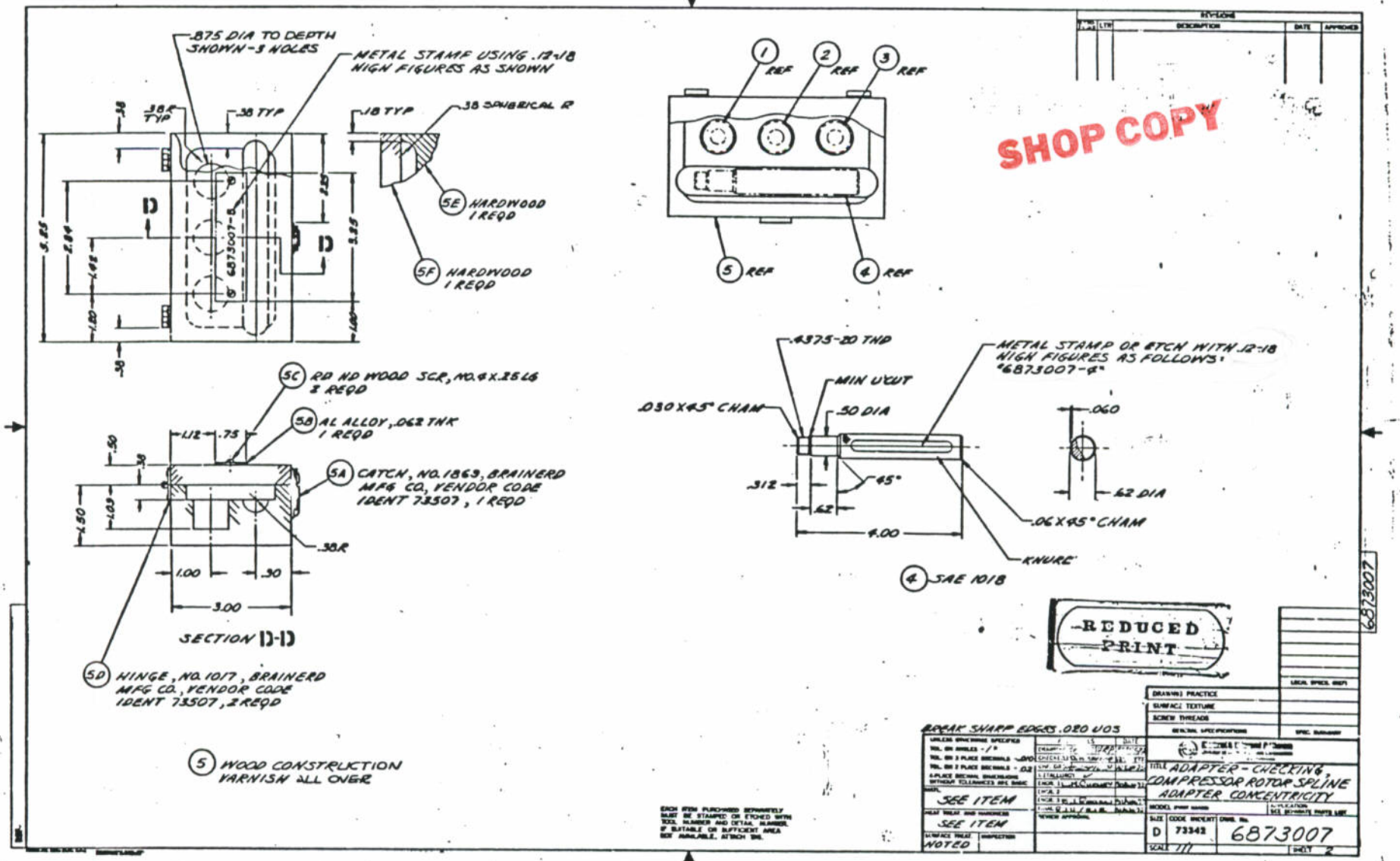
TITLE: ADAPTER-CHECKING, COMPRESSOR ROTOR SPLINE ADAPTER CONCENTRICITY

APPLICATION: SEE SEPARATE PARTS LIST

SIZE	CODE IDENT	DWG. No.
D	73342	6873007

SCALE 2/1 — SHEET 1 OF 2

6873007



.875 DIA TO DEPTH SHOWN-3 HOLES
METAL STAMP USING .12-18 HIGH FIGURES AS SHOWN
.38R TYP
.38 TYP
.18 TYP
.38 SPHERICAL R
5E HARDWOOD 1 REQD
5F HARDWOOD 1 REQD
6873007-B
5C RD HD WOOD SCR, NO.4 X .25 LG 2 REQD
5B AL ALLOY, .062 THK 1 REQD
5A CATCH, NO.1863, BRAINERD MFG CO, VENDOR CODE IDENT 73507, 1 REQD
.38R
SECTION D-D
5D HINGE, NO.1017, BRAINERD MFG CO, VENDOR CODE IDENT 73507, 2 REQD
5 WOOD CONSTRUCTION VARNISH ALL OVER
1 REF
2 REF
3 REF
5 REF
4 REF
.4375-20 THD
MIN U'CUT
.030 X 45° CHAM
.50 DIA
METAL STAMP OR ETCH WITH .12-18 HIGH FIGURES AS FOLLOWS: "6873007-4"
.060
.62 DIA
.312
45°
.62
4.00
.06 X 45° CHAM
KNURE
4 SAE 1018
SHOP COPY
REDUCED PRINT
BREAK SHARP EDGES .020 UOS
SEE ITEM
SEE ITEM
NOTED
ADAPTER - CHECKING, COMPRESSOR ROTOR SPLINE ADAPTER CONCENTRICITY
D
73342
6873007
SCALE 1/1
SHEET 2
6873007